

Date: Tuesday, 11/27/2007 7:46:09 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	JOGGLE BRACKET
Job Number	35983	Part Number	D35801
Estimate Number	12912	Drawing Number	D3580 REV B
P.O. Number	N/A	Project Number	N/A
This Issue	11/27/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Revision	B
First Issue	N/A	Material	N/A
Previous Run	35320	Due Date	12/12/2007
Written By	HJ 07-11-27		
Checked & Approved By			
Comment	Est Rev:A New Issue 07.06.25 EC Est Rev:B Removed Powder Coat 07-07-11 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S18GA	304/316 .050 Sheet  945
2.0	WATER JET	FLOW WATER JET
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  HR 07-11-29
4.0	QC8	SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: FLOW WATER JET  
1-Cut as per Dwg D3580  
Dwg Rev: B HR 07-11-29  
Prog Rev: B

Comment: INSPECT PARTS AS THEY COME OFF MACHINE  
HR 07-11-29

Comment: SECOND CHECK  
5 02/12/03 x90

Comment: Bend as per dwg D3580 using 1/8" offset die  
J 07/12/21 SB 07/12/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/01/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/27/2007 7:46:09 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JOGGLE BRACKET

Job Number: 35983

Part Number: D35801

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

✓ 11/27/07 (90) *coats*

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST110

AS 07/27/07 (90)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/21/07 (90)

Job Completion



✓ 2008/1/2

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>35983</b>
<b>Description:</b> Joggle Bracket	<b>Part Number:</b>	<b>D3580-1</b>
<b>Inspection Dwg:</b> D3580 <b>Rev:</b> B		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

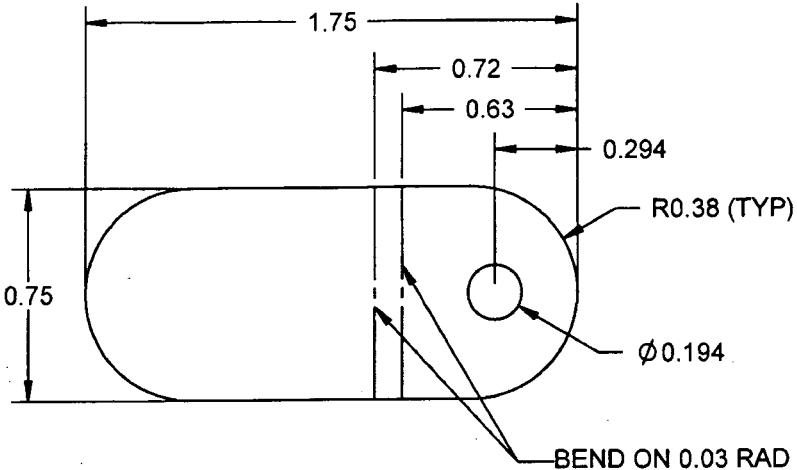
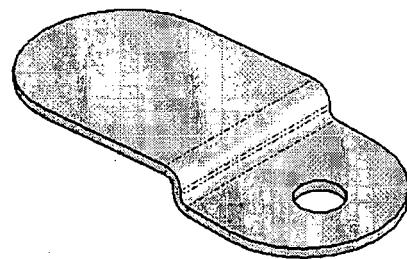
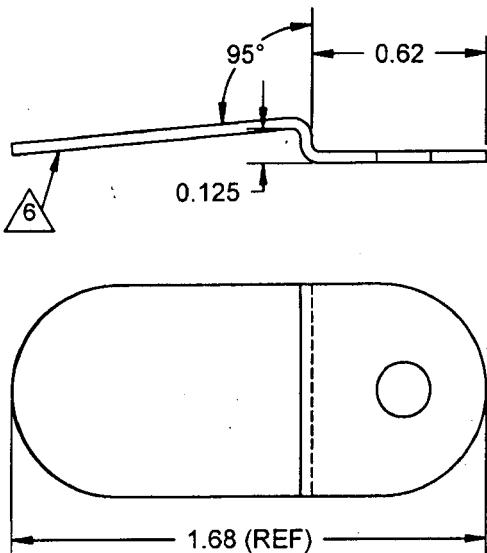
## X First Article      Prototype

Measured by: <u>HB</u>	Audited by: <u>J</u>	Prototype Approval:	N/A
Date: <u>07-11-09</u>	Date: <u>07/12/09</u>		Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	<i>[Signature]</i>

**DART**

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>MM</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE <b>JOGGLE BRACKET</b>	SCALE 3:2
REV A	DATE 07.05.15	DESCRIPTION NEW ISSUE	
REV B	DATE 07.07.09	DESCRIPTION REMOVE POWDER COAT	

**RELEASED**07.07.09 *MM***D3580-1F FLAT PATTERN****D3580-1 JOGGLE BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *35983*

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